

Date: Thursday, 24/07/2008 8:20:48 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
 Job Number : 40606
 Estimate Number : 13435
 P.O. Number :
 This Issue : 24/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 17/07/2008 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-07-24
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB674300111
 Drawing Number : B6743001 P.8
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 24/07/2008 Qty: 5 Um: Eac

Duplicate split 2

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001247	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 340639

MF 08-07-24

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: 10539

MF 08-07-24

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045

MF 08-07-24

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

MF 08-07-24

5.0	PB674300167	PB67-43001-67
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-67

batch: 340243

MF 08-07-24

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Order Number: 40606

Part Number: PB674300111

Order Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

08-07-22

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-07-24(5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (X) 08-07-29

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT

17935

08-07-29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helicol
- 3- install helicol insert as per dwg

08-07-29 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-07-29 (5)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(5X)

- 1- MASK TUBE FROM BASE TO GUSSET

08-07-31

- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

08/07/31

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
320
3:00

m-h

08/07/31 (5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31 (5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

90 Degree Cover Plate

batch: 400069

was done for 2 only see split

08.08.26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

08.08.26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 18836

08.08.26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 106242 108700

08.08.26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

08.08.26

Process Sheet

Order: CU-DAR001 Dart Helicopters Services





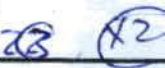


Drawing Name: FWD ADJUSTABLE BLADE SUPPORT

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		<i>S 00/0/23</i> 
21.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		<i>S 00/0/23</i> 
Identify and Stock		
Location: <i>cart welding</i>		<i>S 00/0/23</i> 
22.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



MF 08-10-23

